

86760

July-06-12 2:18:39 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust, Item ID:

20

20

Customer:

Run Start *NR1*

Date: 12-07-9

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O: 86760		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3401-041 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 12/12 Date: 12/01/02
 Resolution: _____ Disposition: Scrap QA: N/C Closed: 12/11/05 Date: 12/11/05

NCR: 12-1984		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/9/13	130	ORIGIN OFFSET WAS WRONG Thickness of loop is 0.450 instead of 0.550. (Qty 12)	DAS 12/9/13	SCRAP.	D.A. 12/09/14 ☹	DAS 16 12/9/14	DAS 16 12/9/13	DAS 16 12/09/14
		R.C. operator entered wrong information in HAAS operator error		124.59 x 2 #249.18				

NOTE: Date & initial all entries

Work Order ID 86760

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Item ID: D3401-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tow Cap Assembly
 Start Date: 7/06/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo Machine as per Folio FA532 and Dwg D3401 Dwg Rev: <u>B</u> Folio Rev: <u>AA</u> Identify as D3401-1 Deburr & Buff rad as per Dwg D3401	0.00 0.00				18	2		
135 *135* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				18			
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				18			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries /

86760

July-06-12 2:18:39 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 7/06/12 **Start Qty:** 20.00

20

Required Date: 8/10/12 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

150

Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

Drill-18
c. simple 10

9

Im 12-10-15
~~FF~~ 12-10-23

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

SmB
12.10.20

DE

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

18

RG/2-10.24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 86760

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Item ID: D3401-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tow Cap Assembly
 Start Date: 7/06/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:30								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 3:00								
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
195	Assemble as per dwg	0.00							
195									
HandFinish	Memo	0.00							
Hand Finishing									

18x 0 12/10/24 12/10/24 18x 0 12/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 86760

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Item ID: D3401-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tow Cap Assembly
 Start Date: 7/06/12 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location: <u>FP-2</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

18 0 12-10-25

x18 6 Ill n/10/27

12/10/29

12-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 2:18:39 PM

Page 1

Work Order ID: 86760

Parent Item: D3401-041

Parent Item Name: Tow Cap Assembly

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.500 6061 RD bar 3.50		Purchased	No			200	f	8.8400	0.35	7.368422			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT036		8.84							
				119231		0.4							
				120708		0.44							
				122321		8							
NAS1330C3KB116 Insert		Purchased	No	122521		100	Each	418.0000	4				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST276		418							
				102606		18							
				103337		400							

DAS
13
9-63

12/9/7

7.5

4 72

12/10/25

X72

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

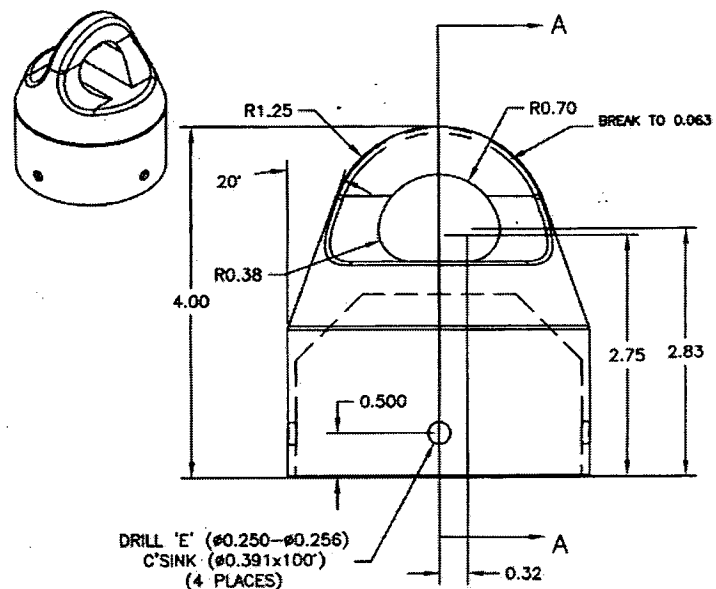
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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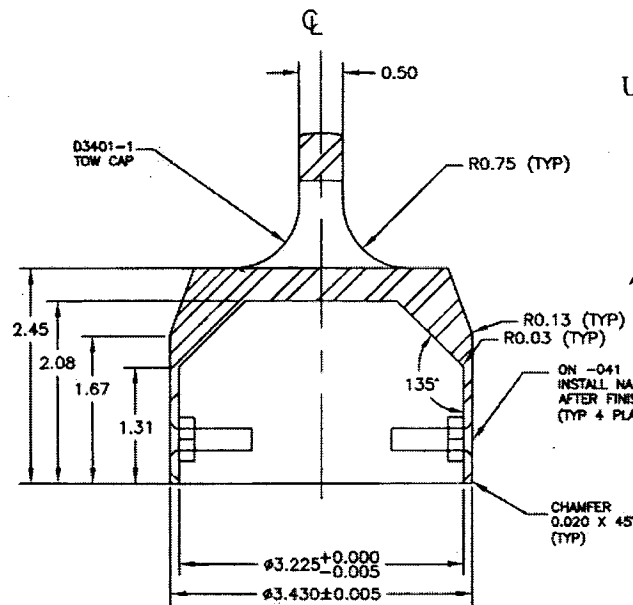
STATION COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *24760*

DART

2/12/07-9



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DATE	TITLE	REV. B
PH	PH	05.06.09	TOW CAP	1:2
CHECKED	APPROVED	05.02.24	NEW ISSUE	
		05.06.09	CHAMFER INSIDE, REMOVE RADIUS	

RELEASED
05-08-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries